

Work Order ID 62427

September 30, 2010 7:59:45 AM



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Item ID: D4172-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Angle

Start Date: 9/30/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/08/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 10/9/30 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

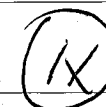
Revision Nbr

D4172

A

0.00

M-1 10/09/30



100



Small Fab

Memo

0.00

Small Fab

- 1- Cut to length as per dwg
- 2- Use DT9657 to drill holes in angle, open to size as per dwg
- 3- C'sink holes as per dwg
- 4- Deburr holes

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/10/6



Pk →

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

BR 10-10-6



Review w/ E.D

NCR's

Why not caught during Prelim or validation stage.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4172-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>62427</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
16-10-01	100-2	HOLE SERIES PER DETAIL A SHIFTED BY 0.020" ON THE 5.500" DIA (D2-6) RC: JIG NOT PROPERLY PREPARED		THIS DEVIATION IS ACCEPTABLE ON THE BASIS THAT ALL THE HOLES ARE STILL WITHIN 0.010" FROM EACH OTHER,	M-1 10/10/05	S 10/10/05	S 10.10.01	S 10/10/01
		AT THE END STOPPER. FLASH OF WELDING PREVENTING FROM LOCATING PART CORRECTLY.	10.10.01	PER DRAWING. FURTHERMORE, THERE IS ENOUGH CLEARANCE AND PLAT PROVIDED BY THE NOTPLATE TO COMPENSATE.		S 10/10/06	S 05.10.02	S 10/10/01
10/10/01	# 100	Found at inspection that Dia .563 was measuring from one end .553 - and the other .583 RC new jig is off.	10.10.04	SCRAP PARTS. CORRECT OR MAKE NEW DRILLING JIG, PRIOR TO MAKING REPLACEMENT FOR SHAPED PARTS SCRAPPED	10.10.04 M-1 10/10/05	S 10/10/05	10.10.04	S 10/10/01

NOTE: Date & initial all entries

Work Order ID 62427

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Item ID: D4172-3

Accept

Revision ID:

Item Name: Support Angle

Start Date: 9/30/10 Start Qty: 1.00

Required Date: 10/08/10 Req'd Qty: 1.00




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		→ 10/10/06		1	0		
140  Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00		10/10/06					10/10/06
150  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/10/07

MF
10-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62427

Parent Item: D4172-3

Parent Item Name: Support Angle



Start Date: 9/30/10

Required Date: 10/08/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A1.000W.125		Purchased	No			100	f	90.9100	6.25	6.578947			
6061T6 ANGLE 1.00 x 1.00 x .125W													

Location

MAT

115688

115776 ✓

Loc Qty

90.91

10.91

80

Loc Code

6.578947

M-L 10/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

